

Work Order ID 65289

January 11, 2011 9:13:04 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

BE 11/01/13

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BE 11/01/19

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch:

M111385/M116577

BE 11/01/19

4- grind fwd cap weld on top surface only

BE 11/01/19

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Clean DT8025 in position and install pilot hole drill jig DT8742A,B,C,D
Drill 3/16" pilot holes as per Dwg D3274

BE 11/01/20

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

114



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. Schultz

Memo

0.00

116



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S. Schultz

Memo

0.00

(40)

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

1 0 BE 10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ 11/01/11 ☐Sikaflex expire date: 11-09-30 ☐Start: 11/01/11 Time: 10:30 ☐Finish: 11/01/11 Time: 8:30 ☐

(Adhere for 12 hours)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulair 125



170

Skidtubes

0.00



Skidtubes

Memo

0.00

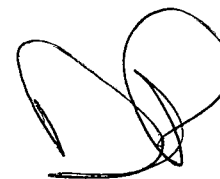
Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding



11-1-26

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

3.0"



QC

Memo

0.00

Quality Control

1 0 BE11/01/27

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R ☐ Aluminum Rod ☒ M11/3B5

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

1 0 BE11/01/28

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		816131					
210 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		816131		(X)			
220 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch	0.00 0.00		=> 91 11/61/31		1 d			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 115951</i> Memo START TIME: <i>9:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:30</i>	0.00 0.00				<i>1</i>	<i>10</i>	<i>11-02-1</i>	
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>= 7</i>	<i>11/02/01</i>		<i>1</i>	<i>0</i>		
250 HandFinish Hand Finishing	HandFinishing Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> LPS-3 <i>M 109956</i> 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> Sikaflex-291 <i>M 115 114</i> Sikaflex expire date: <i>11/01</i>	0.00 0.00	<i>11</i>	<i>11/02/01</i>		<i>1</i>	<i>7</i>		

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC5- Inspect part completeness to step on W/O

0.00

8/102/01

(+)

QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

270

HAND FINISHING RESOURCE #1

0.00

⇒ H 11/02/01

x1

Ø

HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ 1115114 ☐

Sikaflex expire date: 11/01

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: N/A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ 1115114 ☐

Sikaflex expire date: 11/01

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

w/02/10

(70)

290

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PN 65289

Cap/2/10

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

w/02/10

ME
11-02-10

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 65289

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190 		Manufactured	No			110	Each	52.0000	1	1			
Extrusion Round 3" 206													

Location	Loc Qty	Loc Code
LG	52	
47575	4	
59874	48	

BE 11/01/13

D3285-1 		Manufactured	No			110	Each	122.0000	1	1			
Cap													

Location	Loc Qty	Loc Code
LG	122	
52511	74	
52647	48	

BE 11/01/19

D3282-041 		Manufactured	No			150	Each	1.0000	1	1			
Float Web (206L/407)													

Location	Loc Qty	Loc Code
LG	1	
63389	1	

BE 11/01/14

B 65292 (x1)

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Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

53.0000

12

12



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

53

58545

2

60652

4

61496

2

62889

13

63359

32



BE 1/11/27
B 65317 *12

D3275-1

Manufactured No

190

Each

28.0000

12

12



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

28

53453

8

62399

1

63546

19



BE 1/11/27
B 65295 *12

CR3212-4-03

Purchased No

250

Each

1,869.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1869

110153

35

111359

5

112314

2

114436

448

114450

33

114859

1346



BE 1/10/2011
M 110139 y2

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube



Start Date: 1/11/11



Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No 250 Each 33.0000 1 1
  11/02/01
 Nut Plate

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
CCR264SS3-3 Purchased No 250 Each 310.0000 2 2   <u>11/02/01</u> Cherry Rivet	ST056	33	
	<u>33842</u>	33	

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ALS4-1032-130 Purchased No 250 Each 1,129.000 78 78   <u>11/02/01</u> Insert	ST311	310	
	112314	4	
	113539	44	
	<u>113973</u>	262	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
PKG11	550	
114407	3	
114723	547	
ST281	444	
<u>116049</u>	444	
ST282	96	
<u>110511</u>	10	
115911	86	
ST381	39	
114654	39	

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Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D3536-15

Manufactured No

270 Each

18.0000

1

1



Gasket



11/02/01

Location

Loc Qty

Loc Code

FP

1

56055

1

FP011

16

63568

16

FP11

1

59238

1

X1

D3536-23

Manufactured No

270 Each

11.0000

1

1



Gasket



11/02/01

Location

Loc Qty

Loc Code

FP011

11

63570

11

V1

D3536-35

Manufactured No

270 Each

7.0000

1

1



Gasket



11/02/01

Location

Loc Qty

Loc Code

FP012

7

58683

1

63579

6

1365573

V1

D3536-39

Manufactured No

270 Each

15.0000

1

1



Gasket



11/02/01

Location

Loc Qty

Loc Code

FP012

14

63578

14

FP12

1

58215

1

X1

January 11, 2011 9:12:52 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:12:53 AM

Page 5

Work Order ID: 65289

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11



Start Qty: 1.00

Required Qty: 1.00

D3535-15 Manufactured No 270 Each 11.0000 1 1
  xl 11/02/01
Wearshoe

Location Loc Qty Loc Code



FP18 11
63569 11 xl

D3535-35 Manufactured No 270 Each 8.0000 1 1
  xl 11/02/01
Wearshoe

365926

Location Loc Qty Loc Code



FP018 8
63577 8

D3535-39 Manufactured No 270 Each 21.0000 1 1
  xl 11/02/01
Wearshoe

Location Loc Qty Loc Code

FP18 8
62945 8 xl

FP-18 13
64076 13

D3535-23 Manufactured No 270 Each 15.0000 1 1
  xl 11/02/01
Wearshoe

Location Loc Qty Loc Code

FP021 15
62706 1
63571 13 xl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:12:53 AM

Page 6

Work Order ID: 65289

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

270

Each

10.0000

1

1



Wearpad



all 11/02/01

Location

Loc Qty

Loc Code

FP17

10

62705

10

xl

D3537-1 Manufactured No

270

Each

39.0000

9

9



Wearpad



all 11/02/01

Location

Loc Qty

Loc Code

FP017

39

63545

2

63997

37

B64424

89

AN960C10L NAS1149C0332 Purchased No

R

270

Each

25.0000

80

80



washer



M115025

784 all 11/02/01

Location

Loc Qty

Loc Code

ST245

25

107534

25

M116025 *

16 all 11/02/01

AN960C416 NAS1149C0463 Purchased No

R

270

Each

29.0000

1

1



washer



all 11/02/01

Location

Loc Qty

Loc Code

ST346

29

100993

29

M115358

xl

January 11, 2011 9:12:53 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:12:54 AM

Page 7

Work Order ID: 65289

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,309.000

2

2



Phenolic Washer



11/02/01

Location

Loc Qty

Loc Code

ST077

1309

42329

10

52505

299

64177

1000

X2

AN3C4A

Purchased

No

270

Each

1,233.000

80

80



BOLT



11/02/01

Location

Loc Qty

Loc Code

ST350

1233

115300

25

115936

208

116075

1000

X50

AN4C5A

Purchased

No

270

Each

449.0000

1

1



BOLT



11/02/01

Location

Loc Qty

Loc Code

ST346

449

110552

1

112243

448

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:12:54 AM

Work Order ID: 65289

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270 Each

84.0000

1

1



Aft Cap



11/02/11

Location

Loc Qty

Loc Code

FP-4

13

57332

13

yl

FP6

17

52663

3

62678

12

63633

2

Return 2010

54

62678

54

D3413-1

Manufactured No

270 Each

25.0000

1

1



Ring



11/02/11

Location

Loc Qty

Loc Code

ST420

17

62961

17

yl

ST473

8

51586

1

53446

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED
07.02.12 **[Signature]**
DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

#65285

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

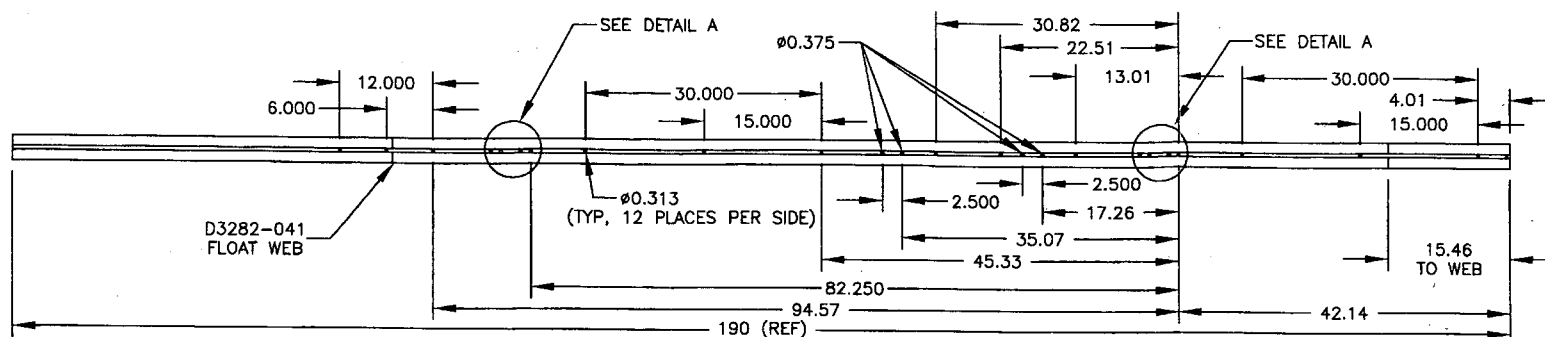
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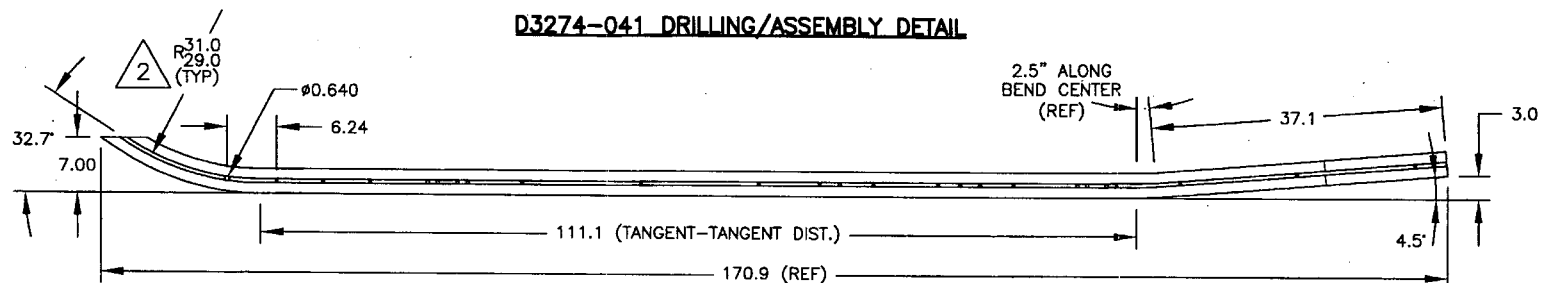
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

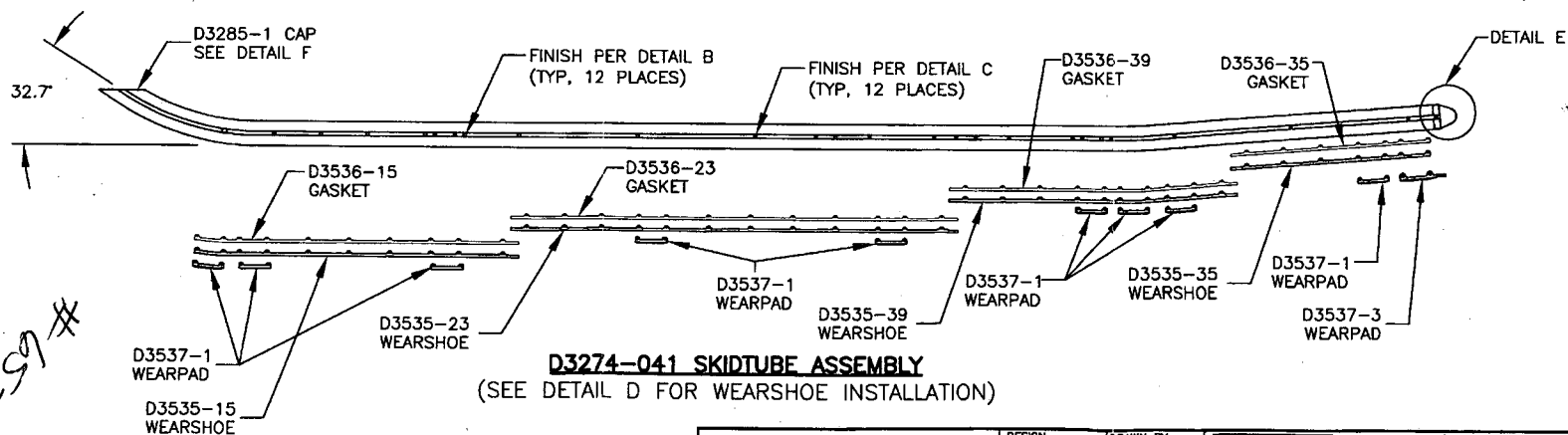
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

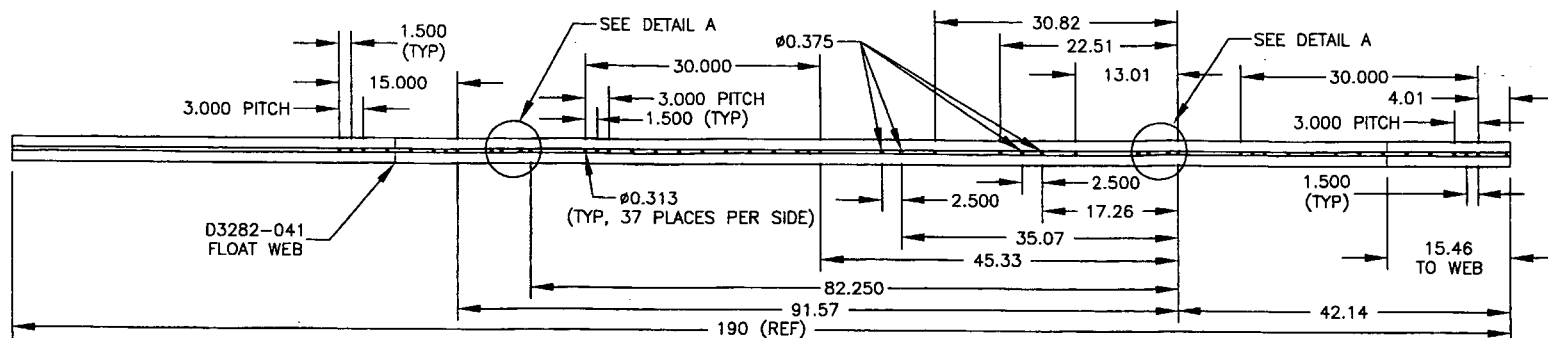
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

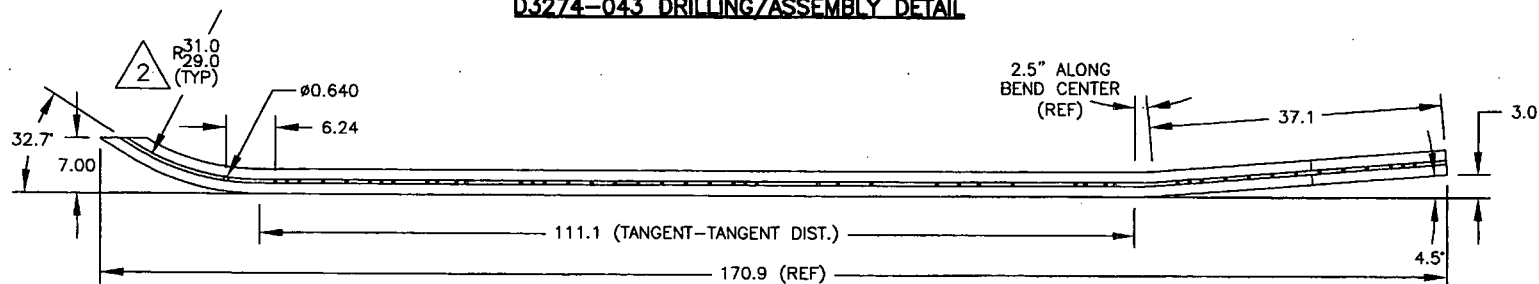
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

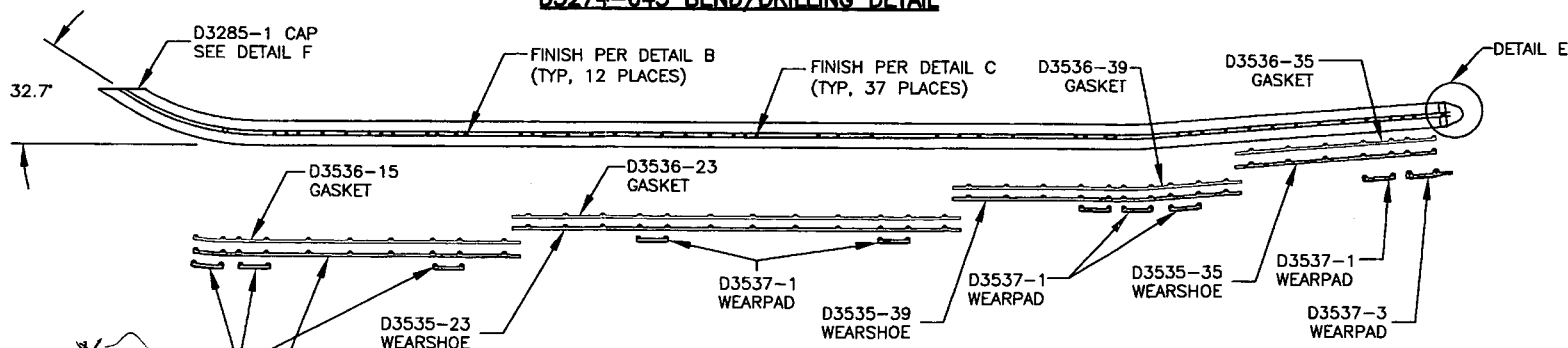
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	H	APPROVED	H	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 3 OF 4 SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

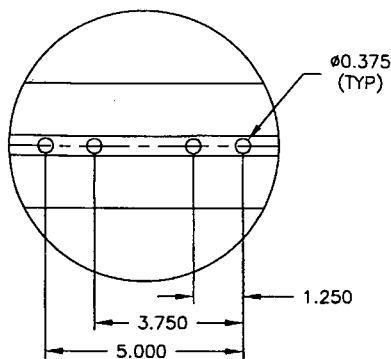
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

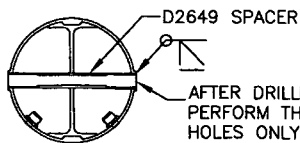
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

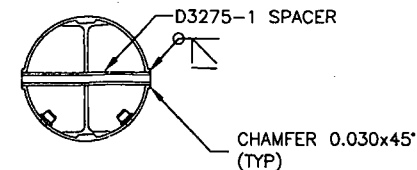


DETAIL B FOR Ø0.375 HOLES ONLY

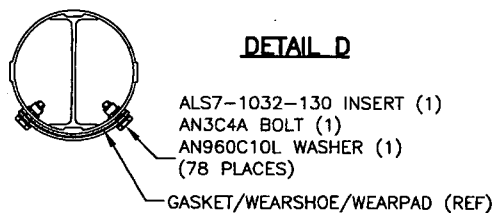


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

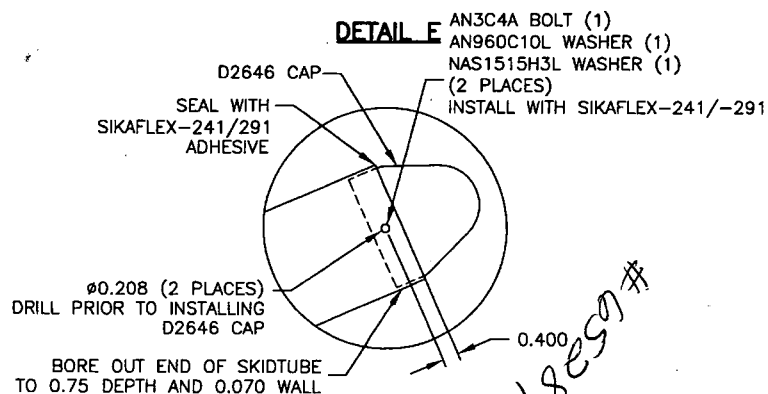
DETAIL C FOR Ø0.313 HOLES ONLY



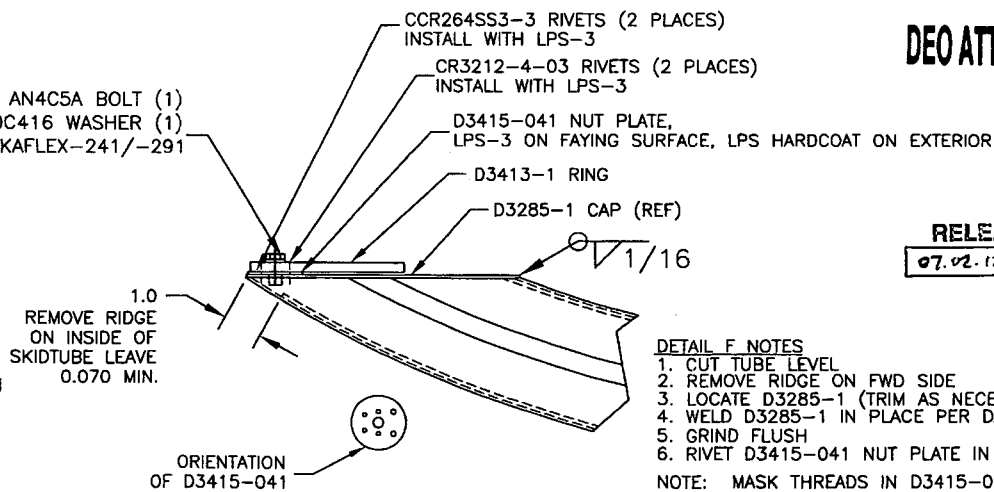
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED
07.02.12

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DATE 06.12.19		CHECKED #	APPROVED #	TITLE SKIDTUBE ASSEMBLY	SHEET 4 OF 4 SCALE 1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

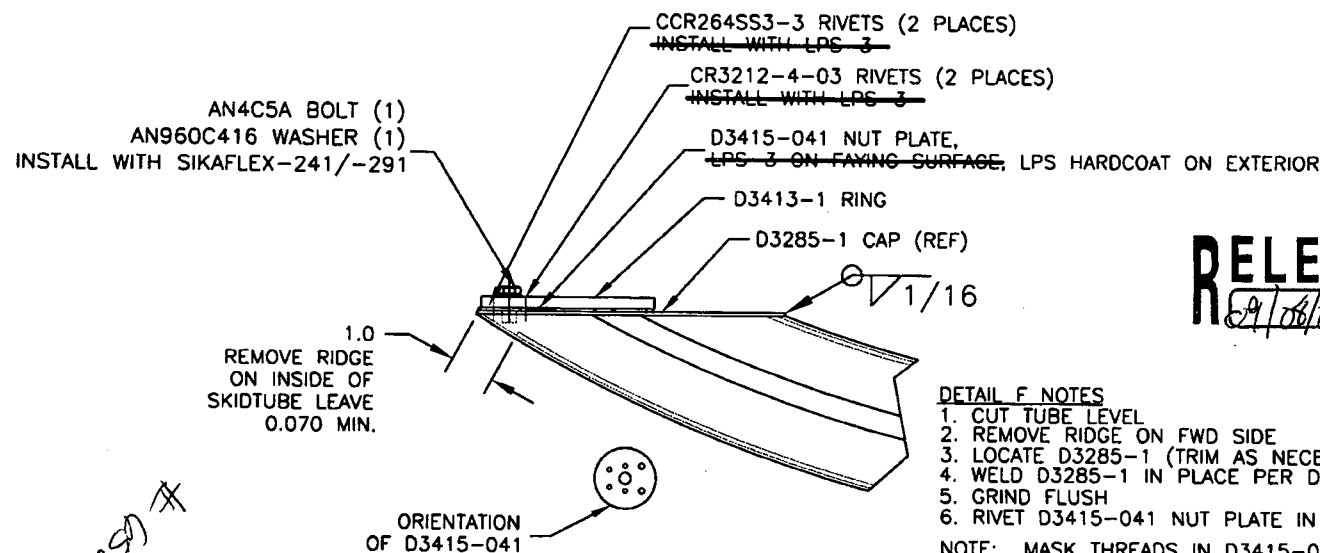
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>A</i>	APPROVED <i>W</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 242

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 65212
Part number: A 206-642-341
Description: 206 Skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Evans Date of Test Coupon 11-01-13
Welder Barclay Elliott Date of Test Coupon 11-01-13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld